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(.880 [22.35])

3.760 [95.50]

0.020 [102.11]



.500 [12.70]

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SECTION A - A

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— (8.00 [203.20])

NOTES:

1. MAKE FROM MDC'S NONROTATABLE VACUUM FLANGE
CAT. #110030
2. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
3. WHEN MACHINING VACUUM PARTS, USE OF
SILICONE AND SULPHUR-BASED CUTTING FLUIDS
IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
4. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
5. FINISHING: WHEN MACHINING VACUUM PARTS USE OF
ABRASIVE PAPER OR SANDING DISCS, BUFFING OR
POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING
WHEELS IS PROHIBITED
6. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT
A UHV PRESSURE OF 1×10^{-9} TORR CAN BE ACHIEVED
7. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH
WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE
DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
8. BREAK ALL SHARP CORNERS 0.03
9. DIMENSIONS IN [] ARE MILLIMETERS AND
FOR REF. ONLY

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM		DWG/PART NUMBER		NOMENCLATURE OR DESCRIPTION				MATERIAL / SPEC		QTY									
<div><div><div>UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES</div><div><div>TOLERANCES</div><table><tr><td>DECIMALS</td><td>ANGULAR</td></tr><tr><td>X - .03 (.7620)</td><td>- .25</td></tr><tr><td>XX - .01 (0.25)</td><td></td></tr><tr><td>XXX - .005 (0.127)</td><td></td></tr></table><div><div>SURFACE ROUGHNESS</div><div>125</div></div><div><div>REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.</div><div>SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1</div><div>DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5</div><div>DO NOT SCALE DRAWING</div></div></div><div><div>LOG NUMBER</div><div>A2342800</div></div><div><div><div><div><div>ARGONNE NATIONAL LABORATORY</div><div>U.S. DEPARTMENT OF ENERGY</div></div><div><div>THIS DRAWING IS THE PROPERTY OF</div><div>ARGONNE NATIONAL LABORATORY</div></div></div><div><div>ADVANCED PHOTON SOURCE</div><div>L2-90 "PINK BEAM" SLIT/BPM LEFT END VACUUM CHAMBER FLANGE</div></div></div></div></div></div>												DECIMALS	ANGULAR	X - .03 (.7620)	- .25	XX - .01 (0.25)		XXX - .005 (0.127)	
DECIMALS	ANGULAR																		
X - .03 (.7620)	- .25																		
XX - .01 (0.25)																			
XXX - .005 (0.127)																			
DRAWN BY		DATE		CHIEF DESIGN ENGINEER		DATE		TITLE											
MUSCIA		3/4/96		D. SHU		6/23/96		<div><div>ADVANCED PHOTON SOURCE</div><div>L2-90 "PINK BEAM" SLIT/BPM LEFT END VACUUM CHAMBER FLANGE</div></div>											
CHECKED BY				GL LEADER															
D. SHU		6/23/96		T.M. KUZAY		6/26/96													
DESIGNER				PROJECT MGR.															
SHU/MUSCIA		3/4/96																	
RESPONSIBLE ENGINEER				APPROVED/RELEASED															
D. SHU		6/23/96																	
MATERIAL		SEE NOTE #1				SCALE		1:1		<div><div>DRAWING NUMBER</div><div>P4105091502-920002-00</div></div>									
						SHEET		1 of 1											

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